

# Work Order ID 66082



Page 1

Thursday, February 03, 2011 3:15:25 PM

Item ID:	D3574-6	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Cabin Floor Protector					
Start Date:	2/4/2011	Start Qty:	2.00		Cust Item ID:	
Required Date:	2/18/2011	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>mf</u>	Date:	<u>11-02-03</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3574	Rev B

100		FLOW WATER JET	0.00						
	Waterjet	Memo	0.00						
	FLOW CNC Waterjet	1-Cut as per Dwg D3574 <input type="checkbox"/> Dwg Rev: <u>B</u> <input type="checkbox"/> Prog Rev: <u>B</u> <input type="checkbox"/> 2-Deburr if necessary							

B11-2-7

(2)

110		QC2- Inspect parts off machine FAI/FAIB	0.00						
	QC	Memo	0.00						
	Quality Control								

B11-2-7

120		QC8- Inspect parts - second check	0.00						
	QC	Memo	0.00						
	Quality Control								

mf

11

02 08

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 66082

Thursday, February 03, 2011 3:15:25 PM



Page 2

Item ID: D3574-6

Accept



Setup Start



Revision ID:

Item Name: Cabin Floor Protector

Stop



Start Date: 2/4/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/18/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

Deburr if necessary.

*Handwritten signature and date: 2/2/11 (2)*

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

*Handwritten signature and date: 2/11/11 02 08 (2)*

150



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

*Handwritten: PNP66081 0.00*

*Handwritten signature and date: 2/11/11 (2)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 66082**

Page 3

Thursday, February 03, 2011 3:15:25 PM

Item ID: D3574-6

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Floor Protector

Start Date: 2/4/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/18/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/09

MF  
11-02-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, February 03, 2011 3:15:19 PM

Page 1

Work Order ID: 66082



Parent Item: D3574-6



Parent Item Name: Cabin Floor Protector

Start Date: 2/4/2011

Required Date: 2/18/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev :A New Issue 07.07.23 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MLEXS.125-F60029-04

Purchased

No

sf

3,417.678

67.23362



GE PLASTICS LEXAN SHEET

11-2-7

Location

Loc Qty

Loc Code

MAT

3417.6788

115261

886.6788

116236

2531

116236

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	100082
<b>Description:</b> Cabin Floor Protector		<b>Part Number:</b>	D3574-6
<b>Inspection Dwg:</b> D3574 <b>Rev:</b> B		<b>Page 1 of 2</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.003	x		V 1802	
7.37	+/-0.030	7.37	x		T 1801	
11.00	+/-0.030	11.00	x		T	
15.25	+/-0.030	15.25	x		T	
25.87	+/-0.030	25.87	x		T	
39.75	+/-0.030	39.75	x		T	
44.75	+/-0.030	44.75	x		T	
58.38	+/-0.030	58.38	x		T	
63.50	+/-0.030	63.50	x		T	
65.25	+/-0.030	65.25	x		T	
10.25	+/-0.030	10.25	x		T	
11.87	+/-0.030	11.87	x		T	
14.75	+/-0.030	14.75	x		T	
26.00	+/-0.030	26.00	x		T	
40.87	+/-0.030	40.87	x		T	
45.00	+/-0.030	45.00	x		T	
48.00	+/-0.030	48.00	x		T	
55.13	+/-0.030	55.13	x		T	
61.25	+/-0.030	61.25	x		T	
61.88	+/-0.030	61.88	x		T	
64.63	+/-0.030	64.63	x		T	
1.13	+/-0.030	1.13	x		T	
7.63	+/-0.030	7.63	x		T	
11.00	+/-0.030	11.00	x		T	
22.10	+/-0.030	22.10	x		T	
22.50	+/-0.030	22.50	x		T	
24.50	+/-0.030	24.50	x		T	
35.13	+/-0.030	35.13	x		T	
36.50	+/-0.030	36.50	x		T	
40.00	+/-0.030	40.00	x		T	
41.88	+/-0.030	41.88	x		T	
43.63	+/-0.030	43.63	x		T	
6.75	+/-0.030	6.75	x		T	
9.50	+/-0.030	9.50	x		T	

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	106082
<b>Description:</b> Cabin Floor Protector		<b>Part Number:</b>	D3574-6
<b>Inspection Dwg:</b> D3574	<b>Rev:</b> B	<b>Page 2 of 2</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.38	+/-0.030	10.38	✓	✓	T 1801	
14.50	+/-0.030	14.50	✓		T	
16.75	+/-0.030	16.75	✓		T	
18.94	+/-0.030	18.94	✓		T	
19.00	+/-0.030	19.00	✓		T	
24.13	+/-0.030	24.13	✓		T	
33.88	+/-0.030	33.88	✓		T	
39.50	+/-0.030	39.50	✓		T	
40.25	+/-0.030	40.25	✓		T	
43.50	+/-0.030	43.50	✓		T	
46.60	+/-0.030	46.60	✓		T	
0.125	+/-0.010	0.130	✓		V 1802	

<b>Measured by:</b> B	<b>Audited by:</b> M.M.	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11-2-7	<b>Date:</b> 11-02-08	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DD	
B	09.05.15	Dimensions updated per Dwg Rev B	KJ	

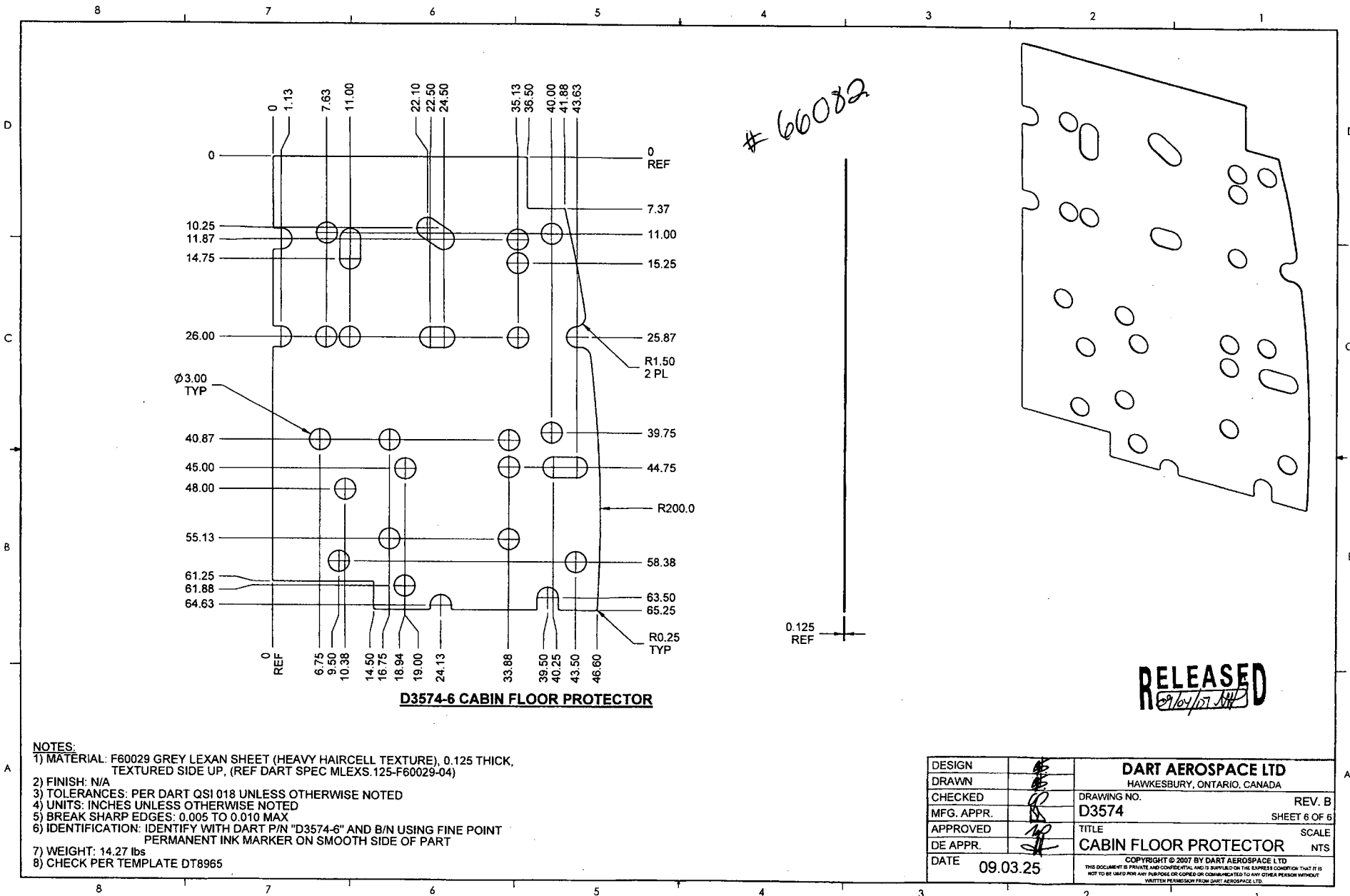
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